





# Work Order ID 59579

Tuesday, June 08, 2010 10:38:28 AM


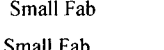
Page 1

Item ID: D3187-2 Accept  Setup Start   
Revision ID: Stop   
Item Name: Spacepod Floor  
Start Date: 6/8/2010 Start Qty: 4.00  Cust Item ID:  
Required Date: 6/11/2010 Req'd Qty: 4.00  Customer:  
Reference: NCR 10-010

Approvals: Process Plan: mf Date: 10-6-8 Tooling: Date: Run Start   
QC: Date: SPC (Y/N): Date: Stop 



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3187	Rev C

200  0.00  
Small Fab  Memo 0.00  
Small Fab PULL FROM STOCK D3187-2 B 31836 X 4  
1- install D2986-1 rubber spacer using contact cement and trim to fit if necessary  
as per dwg D3187 A/R contact cement Batch: 112983 2- transfer  
holes from spacepod floor to rubber spacer


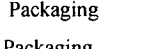
21 10-06-09

210

210  0.00  
QC  Memo 0.00  
Quality Control

8 10/06/07

x4

220  0.00  
Packaging  Memo 0.00  
Packaging ID AND STOCK UNDER NEW BATCH NUMBER

Identify as per dwg & Stock Location: 241

x4

BB

10/06/10

W/O: 59579		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-06-09	200	in stead of using <u>D3187-2 x 4</u> used <u>D3187-2 x 2</u> <u>B 31836</u> <u>D3187-1 x 2</u> <u>B 31835</u>	ET	10-06-09				

Part No: D3187-2 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3187-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacepod Floor

Start Date: 6/8/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 6/11/2010 Req'd Qty: 4.00

Customer:

Reference: NCR 10-010

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/10

P10-6-10  
(4)

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Tuesday, June 08, 2010 10:38:28 AM

Page 1

Work Order ID: 59579



Parent Item: D3187-2



Parent Item Name: Spacepod Floor

Start Date: 6/8/2010

Required Date: 6/11/2010

Comments: IPP: C 05.04.14 Now a purchased part KJ/JLM  
IPP Rev:D Now on Waterjet 07-04-19 JLM  
IPP Rev:E Now Powder Coated 07-05-24 JLM  
IPP Rev:F 09-01-20 rev.C as per dwg DD verified by:EC

Start Qty: 4.00

Required Qty: 4.00

D2986-1

Manufactured No

110

Each

15.0000

1

4



10-06-09

Rubber Spacer

Location

Loc Qty

Loc Code

ST242

15

57659

3

59409

12

4

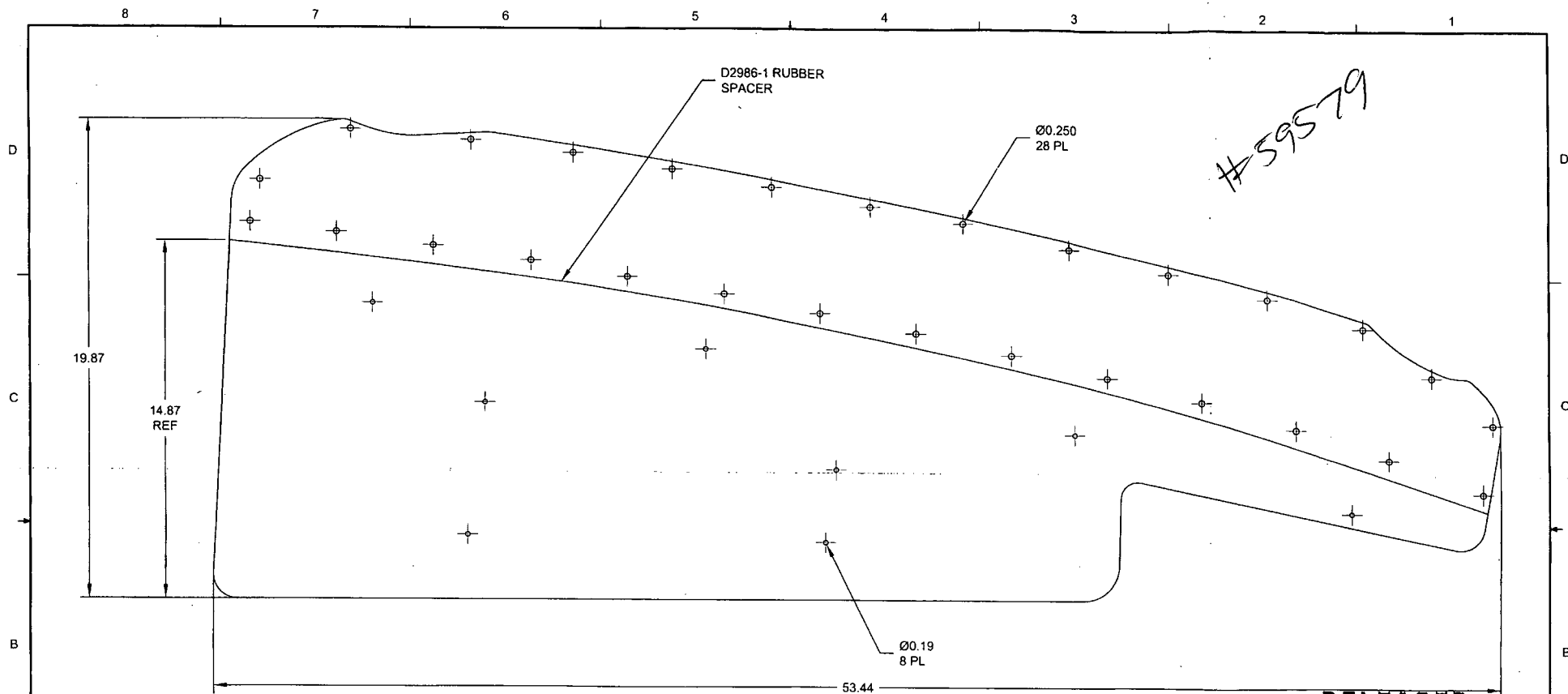
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**NOTE:** Date & initial all entries



**D3187-1 SPACEPOD FLOOR**

**D3187-1 SPACEPOD FLOOR NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.2 LBS
- 8) TOOLING: CUT/DRILL PER TEMPLATE DT3187-1T1
- 9) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT

**RELEASED**  
09.01.05

C	REDRAWN TO CURRENT STANDARDS; TRANSFERRED TO B-SIZE FORMAT; ADDED SHEET 2; CREATED DETAIL FOR D3187-2; REVISED SHEET 1 NOTES. REASON: CLARIFIED DRAWINGS FOR D3187-1/2.	MB	09.01.05
B	CHANGE SHAPE	CP	03.05.16
A	NEW ISSUE	CP	03.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.05		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3187  
TITLE SPACEPOD FLOOR  
SCALE NTS

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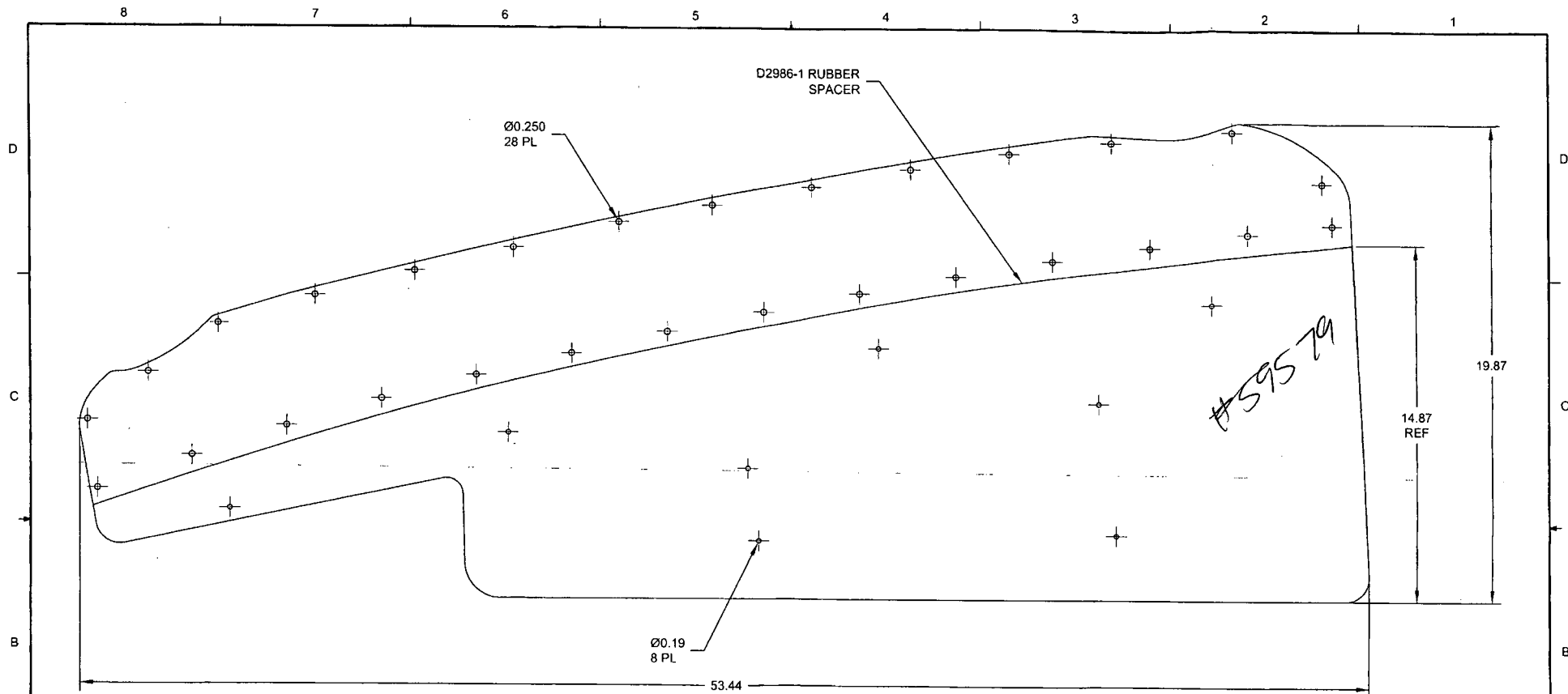
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**D3187-2 SPACEPOD FLOOR**

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**RELEASED**  
09.01.05 JMB

DESIGN	<del>1</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>2</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>3</del>	DRAWING NO.	REV. C
MFG. APPR.	<del>4</del>	D3187	SHEET 2 OF 2
APPROVED	<del>5</del>	TITLE	SCALE
DE APPR.	<del>6</del>	SPACEPOD FLOOR	NTS
DATE	09.01.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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